

Work Order ID 79958

79958

U/R

Page 1

February-08-12 10:15:36 AM

Item ID: D412-742-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: U/R OK 12.02.12 Stop ***NS2***
 Item Name: Replacement Float Skidtube
 Start Date: 08/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-043 CHG005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 22/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 11120318 Expiry date: 12/09								
	2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/RSikaflex-241/-291 11120318 Expiry date: 12/08								
	3-Remove "T" pins once sikaflex is dry.								
	4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon 11114596								

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Required Date: 22/02/2012 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/2/12/12/10					
130 *130* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-742-043 Location: _____ PPP Rev: _____	0.00 0.00		PP 8/088				12/4/13	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MLJ 12/04/13	

12-04-13

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79958

D412-742-043

Required Qty: 1.00

[illegible]

Loc Code

1381117 (x) 44 1204109

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

February-08-12 10:15:40 AM

Page 2

Work Order ID: 79958

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

110 Each 3,795.000 24 24

AN3C4A

BOLT

**

u 12/04/09

Location	Loc Qty	Loc Code
ST350	3795	
117313	2	
117688	5	
117872	10	
118112	16	
118451	2	
119749	260	
120187	2000	
120423	500	
120521	1000	

x24

AN3C6A Purchased No

110 Each 344.0000 10 10

AN3C6A

BOLT

**

u 12/04/09

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	343	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	25	
120423	250	

x10

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Page 3

Work Order ID: 79958

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No

110 Each 85.0000 4 4

AN3C7A

BOLT

**

1120731 (x4) JH 12/04/09

Location

Loc Qty

Loc Code

ST351

85

113149

14

116169

1

117313

10

117619

12

117688

6

119749

42

AN960C10L NAS1149C0332 Purchased No

110 Each 0.0000 38 38

***AN960C10I ***

washer

**

1121255 (x38) JH 12/04/09

D4095-041 Manufactured No

110 Each 13.0000 1 1

D4095-041

Wearplate Assembly

**

B78996 (x1) JH 12/04/09

Location

Loc Qty

Loc Code

FP001

13

77438

3

78938

10

D4095-043 Manufactured No

110 Each 3.0000 1 1

D4095-043

Wearplate Assembly

**

B78995 (x1) JH 12/04/09

Location

Loc Qty

Loc Code

FP002

3

77437

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 4

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Parent Item: D412-742-043

D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 08/02/2012

Required Date: 22/02/2012

Start Qty: 1.00

Required Qty: 1.00

D4095-045

Manufactured

No

110

Each

12.0000

1

1

D4095-045

Wearplate Assembly

**

B80702 (x) del n/a 1/09

Location

Loc Qty

Loc Code

FP001

12

77737

1

79042

11

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Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd

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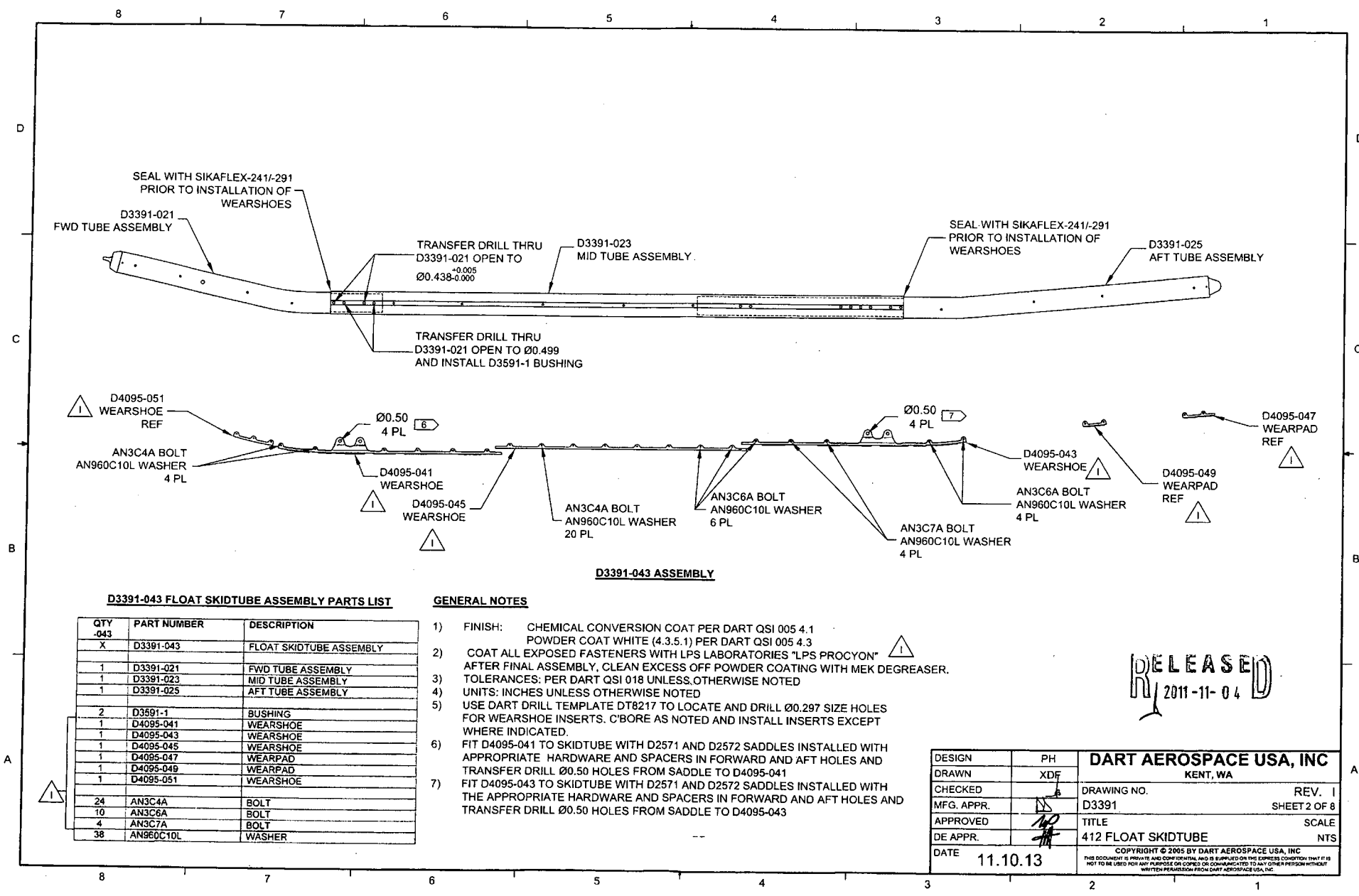
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D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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2011-11-04

DESIGN		PH	DART AEROSPACE USA, INC KENT, WA
DRAWN		XDF	
CHECKED			DRAWING NO. D3391
MFG. APPR.			REV. I SHEET 2 OF 8
APPROVED			TITLE 412 FLOAT SKIDTUBE
DE APPR.			SCALE NTS
DATE 11.10.13		<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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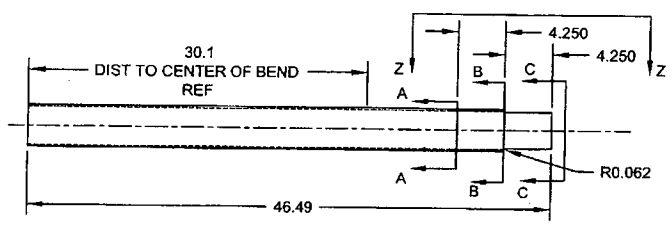
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

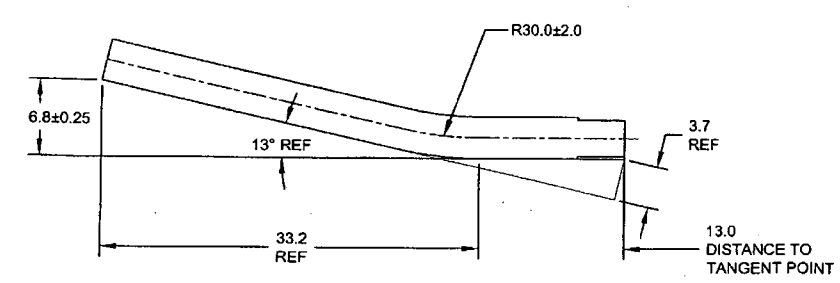
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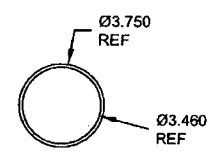
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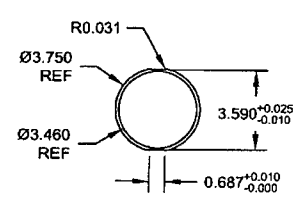
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



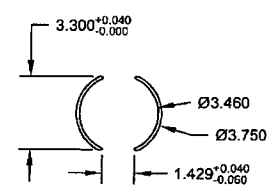
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



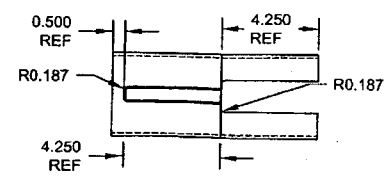
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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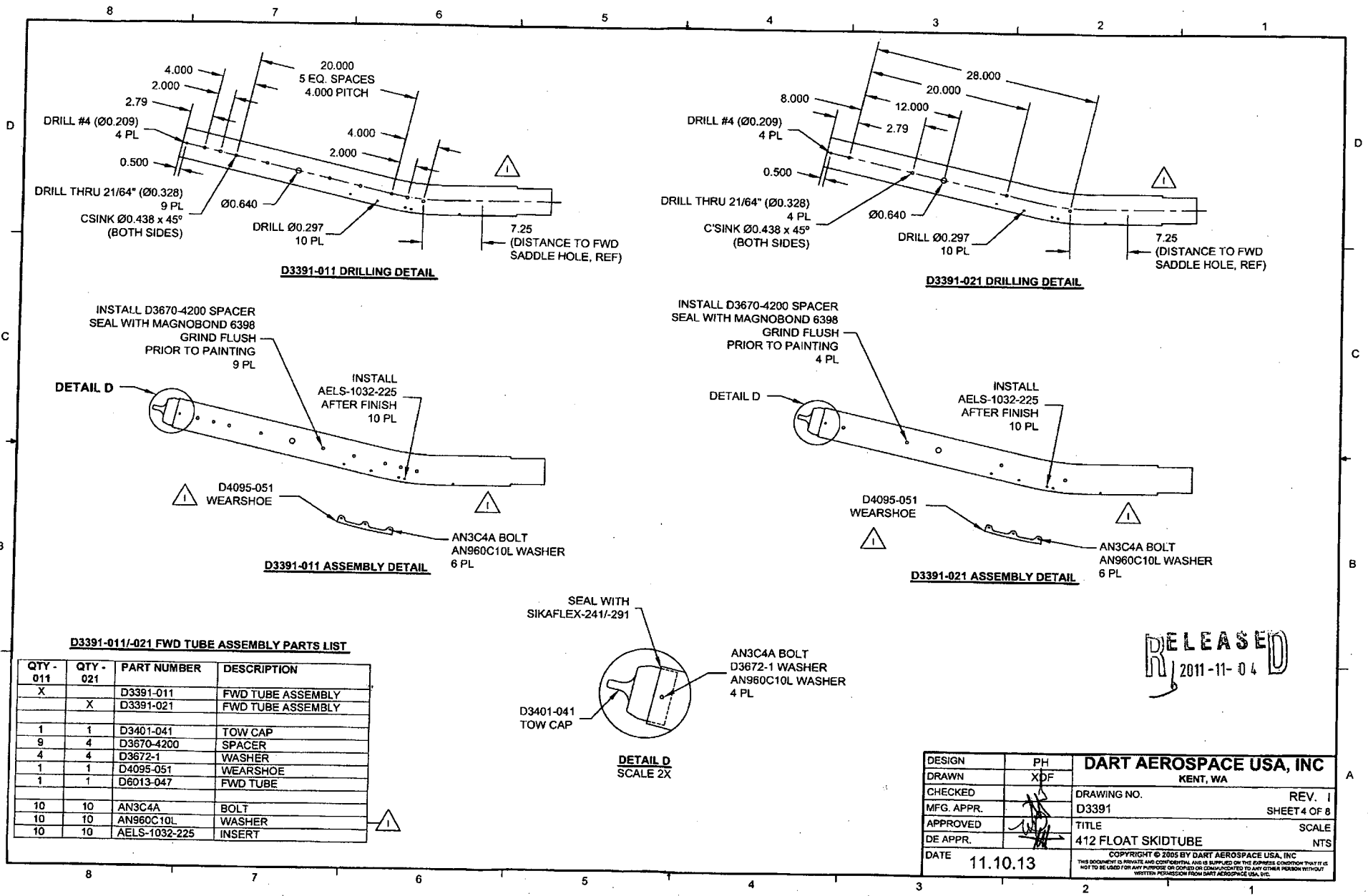
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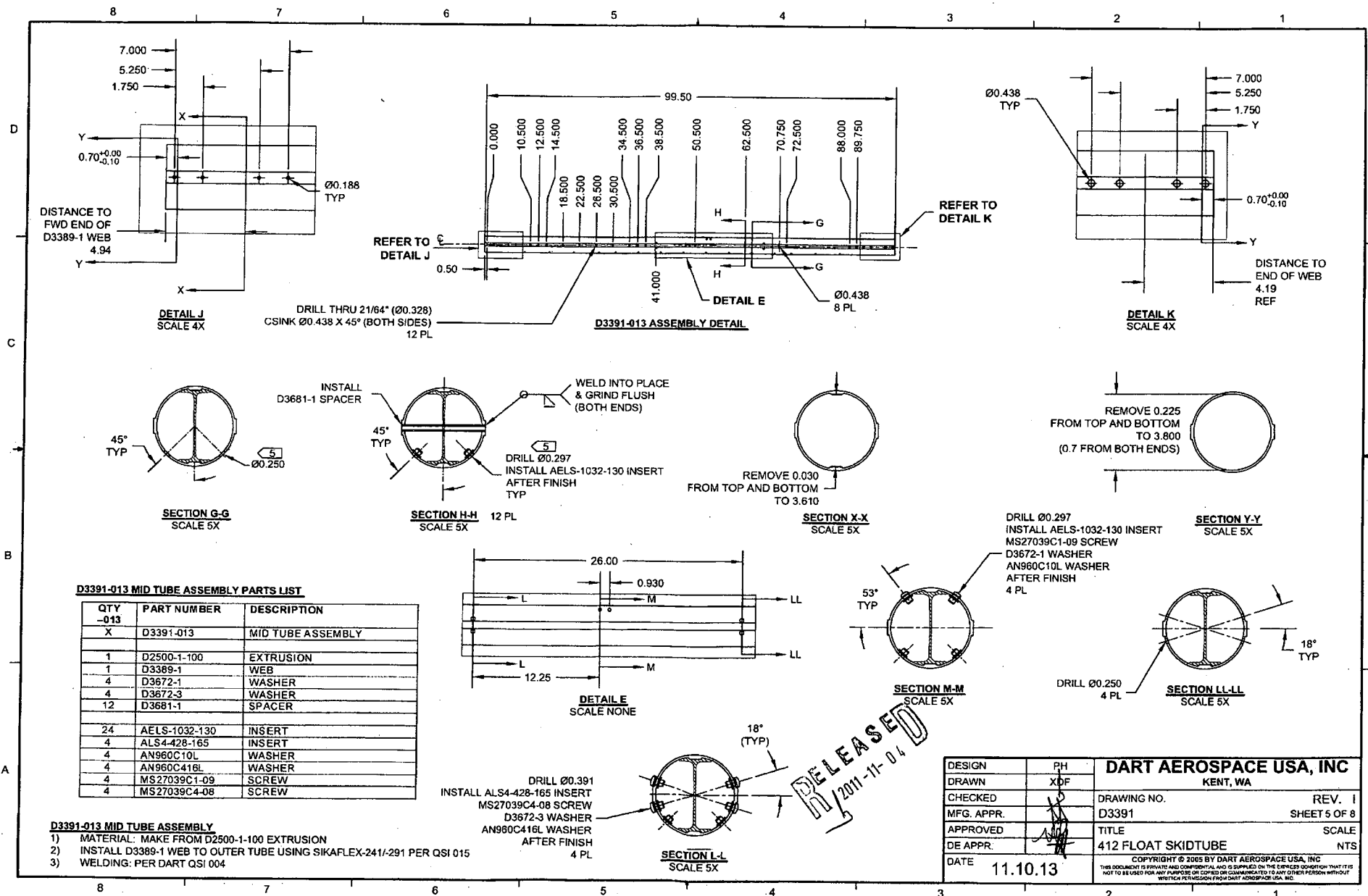
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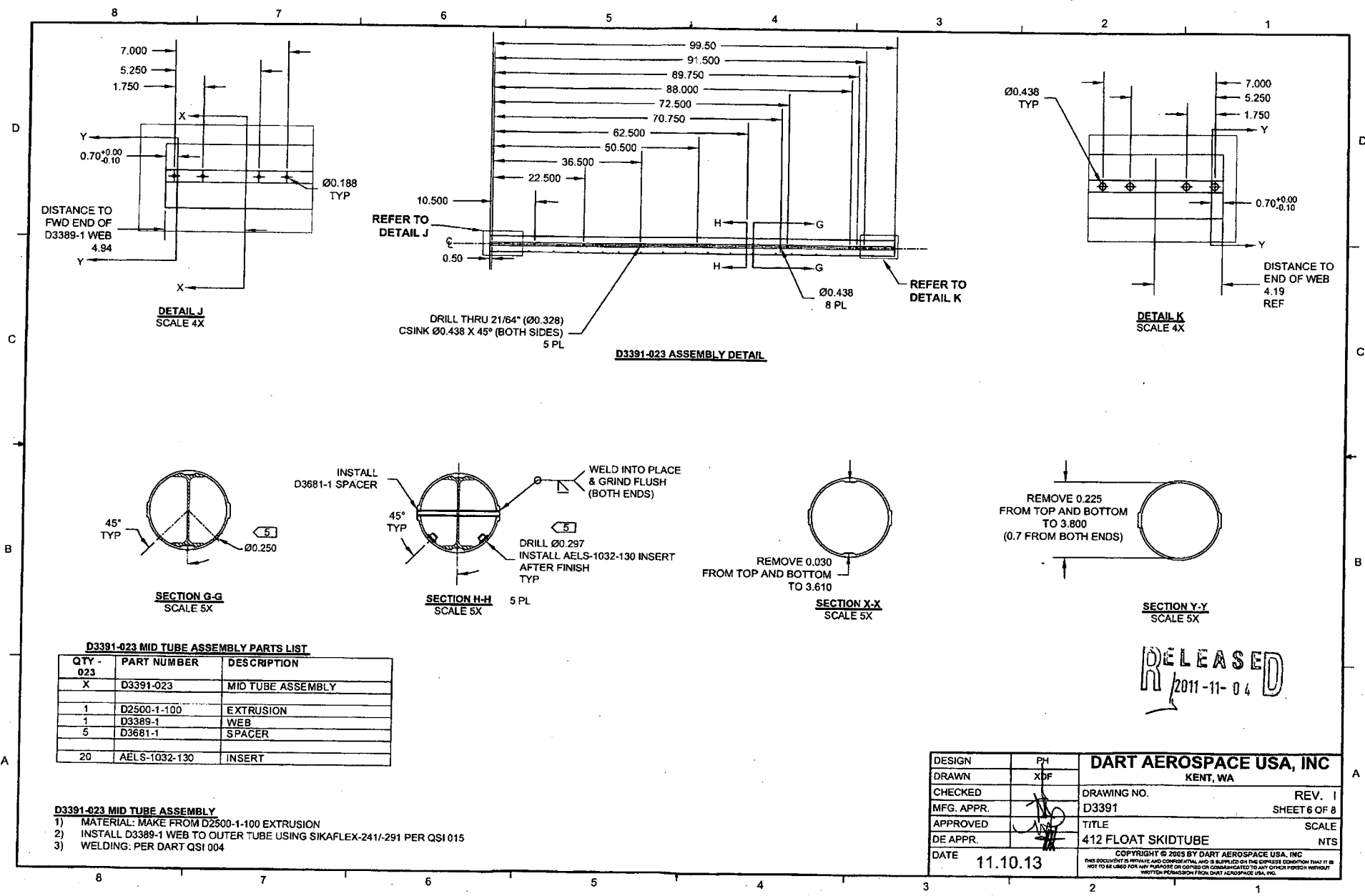
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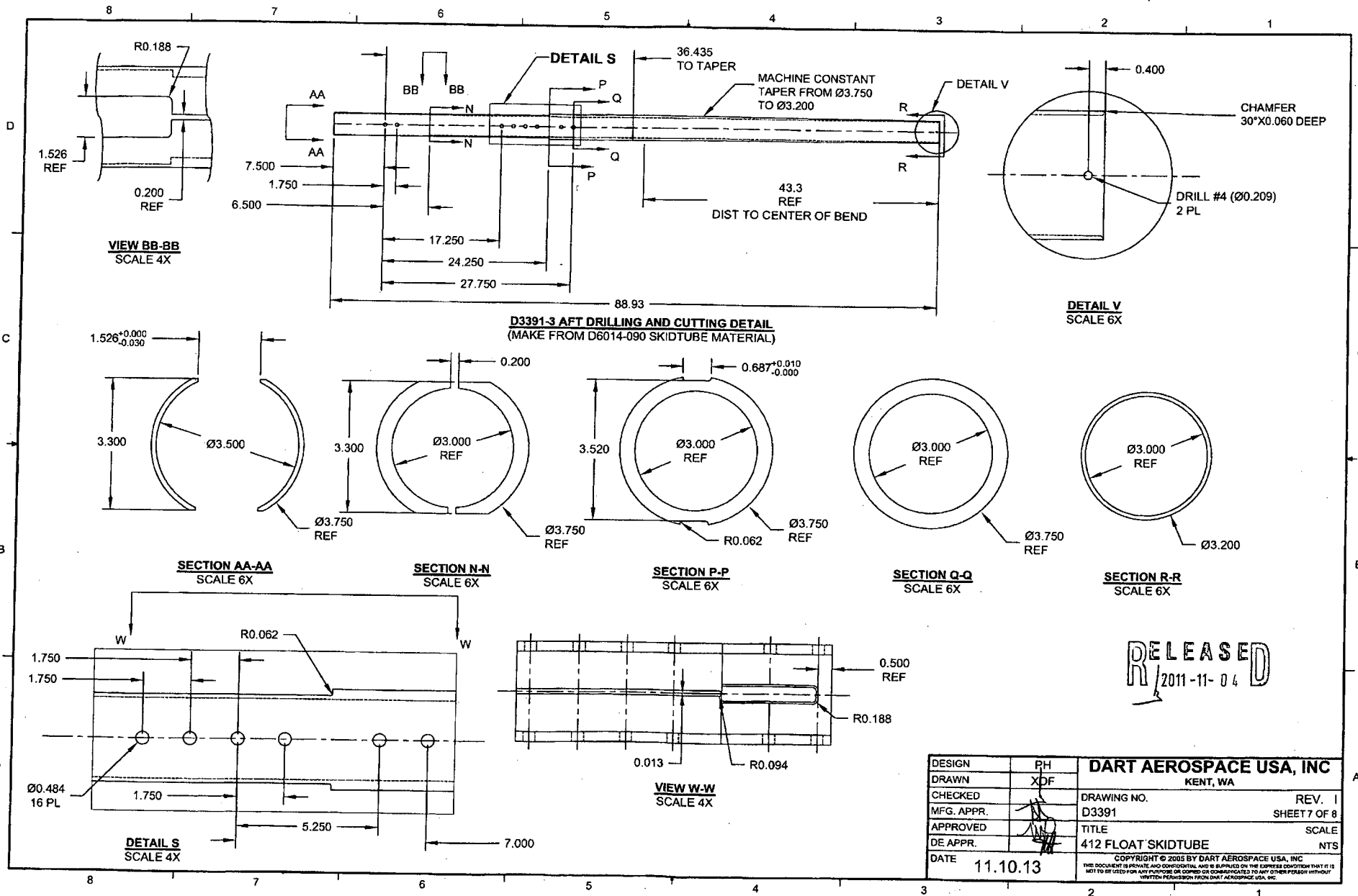
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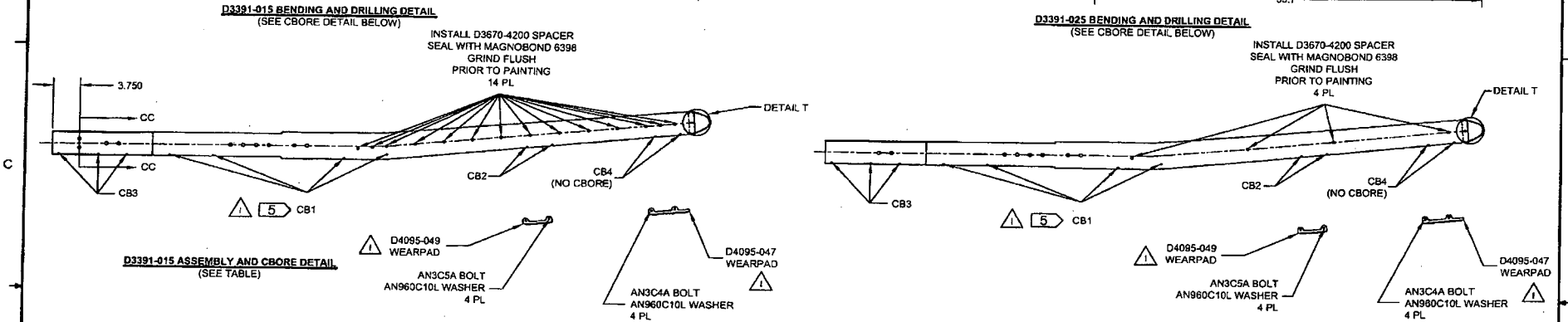
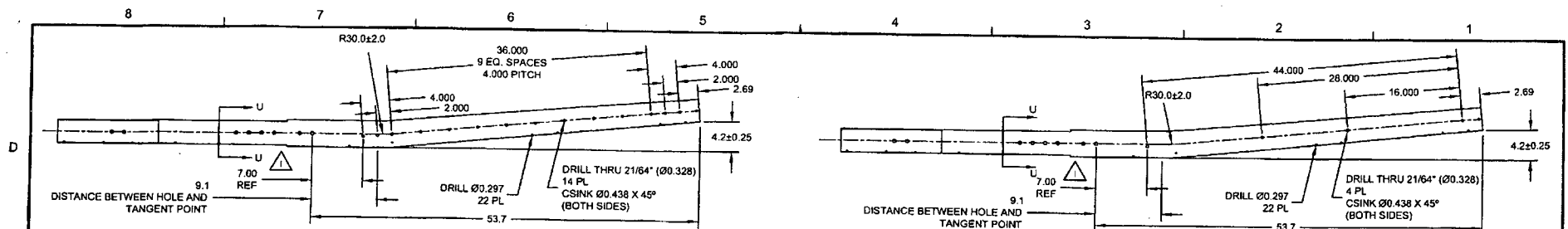
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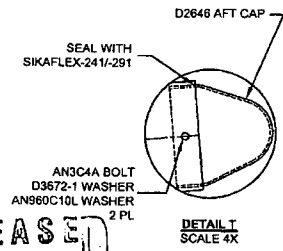
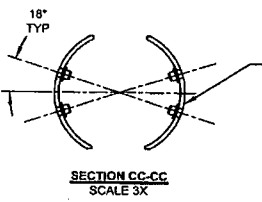


D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
6	8	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries